

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001157**Date Inspected:** 24-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock Ups, OBG components**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Bay 2: As reported on the TL-6031 from 12-23-2007, the QA inspector was unable to continue verifying the partial joint penetration (PJP) welds on the intermediate stiffeners of the 89 meter mock up assembly skin plate "D." The QA inspector returned to this work location to continue the verification. Upon the QA inspector's arrival, the QA inspector noted that the part has been moved and these welds are not accessible.

Bay 3: The QA inspector observed ZPMC personnel operating the gantry mounted flux cored arc welding (FCAW) to make fillet welds on stiffeners of BP003-01. The QA inspector made random observations of this operation. The QA inspector noted that 3 ZPMC welders; Li Shu Liang, Xin Meng and Li Zhao Qian are each manipulating 2 FCAW welders. The QA inspector observed that on top of the gantry, where the electrode wire and voltage controls are located, a ZPMC worker Zhang Qiang is measuring and recording the welding currents of each FCAW machine (6 total). The QA inspector asked Zhang Qiang if there was a CWI monitoring this work. The QA inspector was informed that Xu Xian Ping is the CWI and the QA inspector was shown that the CWI is nearby on the shop floor. The QA inspector noted that the CWI appeared to be monitoring the preheat temperature on the assembly. The QA inspector was unable to make any observations of the welding parameters at this time.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations and conversations. The QA inspector also generated a summary report of these observations to be included in the daily shift notes. There were no other notable conversations during this shift.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

---